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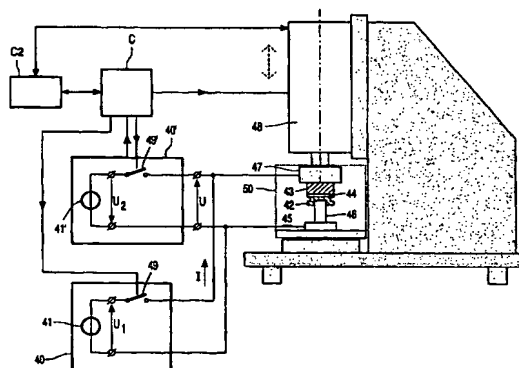
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[Continued on next page]

(54) Title: **A METHOD, AN APPARATUS, A CONTROL SYSTEM AND A COMPUTER PROGRAM TO PERFORM AN AUTOMATIC REMOVAL OF CATHODE DEPOSITIONS DURING A BIPOLAR ELECTROCHEMICAL MACHINING**

(57) Abstract: The invention relates to a method, an apparatus and a computer program for electrochemical machining where a removal of cathode depositions is performed in a fully automated way by means of an application of optimal pulses of a suitable polarity. The method comprises establishing an optimal pulse duration for pulses of the inverse polarity for a removal of the cathode depositions from an electrode surface during the electrochemical machining, said optimal pulse duration being determined from a first calibration carried out preceding the machining of the work piece and a second calibration carried out during the machining of the work piece; performing a control of the machining of the work piece by means of a monitoring of an actual value of an operational parameter and comparing said actual value of the operational parameter to a preset value of the operational parameter; applying a pulse of the inverse polarity of the optimal pulse duration in case the actual value of the operational parameter is greater than the preset value of the operational parameter. The operation of the apparatus 4 in a machining mode is controlled by a process control means C. The operation of the apparatus 4 in an electrode cleaning mode is controlled by the control system C2 arranged to remove the cathode depositions from the surface of the electrode in real time.

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INTERNATIONAL SEARCH REPORT

International application No.

PCT/IB 03/01569

A. CLASSIFICATION OF SUBJECT MATTER

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According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

IPC 7 B23H

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the International search (name of data base and, where practical, search terms used)

EPO-Internal, WPI Data, PAJ

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X A	US 3 654 116 A (INOUE KIYOSHI) 4 April 1972 (1972-04-04) column 1, line 23 - line 33 column 2, line 61 - line 65 column 3, line 1 - line 19 column 4, line 39 - column 5, line 12 column 5, line 24 - line 35 column 9, line 15 - line 30 column 14, line 11 - line 28 column 18, line 21 - column 19, line 56	1,2,5,6, 10-12 3,4, 13-15
A	US 3 616 346 A (INOUE KIYOSHI) 26 October 1971 (1971-10-26) column 1, line 14 - line 19 column 1, line 61 - column 2, line 4 column 6, line 10 - line 25	1-15

☐ Further documents are listed in the continuation of box C.☒ Patent family members are listed in annex.

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